

Work Order ID 55179

January 8, 2010 1:11:14 PM



Page 1

Item ID: D2144

Accept



Setup Start



Revision ID:

Stop



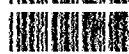
Item Name: Hinge Bracket

Start Date: 08/01/2010 Start Qty: 40.00



Cust Item ID:

Required Date: 18/01/2010 Req'd Qty: 40.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

BP

Date:

10-1-08

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2144

Rev D

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2144
Deburr if necessary

Dwg Rev: *D*

Prog Rev: *D*

2-

B 10-1-12

110

0.00



QC2- Inspect parts off machine FA1/FA1B

QC

Memo

0.00

Quality Control

B 10-1-12

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

27 8/10/11/13

counter
(x52)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55179

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Item Name: Hinge Bracket

Start Date: 08/01/2010 Start Qty: 40.00



Cust Item ID:

Required Date: 18/01/2010 Req'd Qty: 40.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

Deburr if necessary

N/A

140



NC BRAKE

0.00

Brake NC

Memo

0.00

Brake NC

Form as per Dwg D2144Rev: ①

EB 10/01/20

S2

150



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

⇒ 8.10.6.1/21

count
X52

W/O:		WORK ORDER CHANGES					
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Work Order ID 55179

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Item ID: D2144

Accept

Setup Start

Revision ID:

Stop

Item Name: Hinge Bracket

Start Date: 08/01/2010 Start Qty: 40.00

Cost Item ID:

Required Date: 18/01/2010 Req'd Qty: 40.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- Weld corner as per Dwg D2144 & QSI 004 12- Grind flush

10 01.22

52

170

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

10/01/22

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

=> 8/01/22

counter

52

W/O:		WORK ORDER CHANGES					
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Work Order ID 55179

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Start Date: 08/01/2010 Start Qty: 40.00

Cust Item ID:

Required Date: 18/01/2010 Req'd Qty: 40.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

8:30AM

OVEN TEMPERATURE:

9:00AM FINISH TIME

400°F

200

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

210

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

198

10-1-27

52X

=> 10/10/11 52 9

=> m-l w oil 27 52X

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Work Order ID 55179

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Customer ID:

Required Date: 18/01/2010 Req'd Qty: 40.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/27

UMF 10-1-27

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

January 8, 2010 1:11:20 PM

Page 1

Work Order ID: 55179

Parent Item: D2144

Parent Item Name: Hinge Bracket

Start Date: 08/01/2010

Required Date: 18/01/2010

Comments: IPP: D: 04.05.06 Reformat KJ/RF
IPP Rev: E Now on Waterjet 06-10-15 JLM

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			120	sf	356.2779	3.7800	5.		



304/316 Sheet .063



B 10-1-12

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

356.2778737

106860

8.0295

111924

25.1689737

112442

29.8899

113295

293.1895

113295



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	55179
Description: Hinge Bracket		Part Number:	D2144
Inspection Dwg: D2144 Rev: D		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.381	+/-0.010	3.380	X			
3.022	+/-0.010	3.023	X			
2.468	+/-0.010	2.470	X			
1.913	+/-0.010	1.914	X			
1.555	+/-0.010	1.554	X			
4.126	+/-0.010	4.128	X			
3.465	+/-0.010	3.462	X			
0.340	+/-0.010	0.335	X			
0.625	+/-0.010	0.625	X			
1.000	+/-0.010	0.996	X			
1.083	+/-0.010	1.087	X			
1.660	+/-0.010	1.664	X			
2.312	+/-0.010	2.317	X			
2.844	+/-0.010	2.842	X			
3.294	+/-0.010	3.293	X			
Ø0.257	+0.006/-0.001	0.260	X			
Ø0.171	+0.005/-0.001	0.174	X			
Ø0.320	+0.006/-0.001	0.322	X			
0.354	+/-0.010	0.352	X			
0.083	+/-0.010	0.088	X			

Measured by:	B	Audited by:	S	Prototype Approval:	N/A
Date:	10-1-12	Date:	10/6/13	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.31	New Issue	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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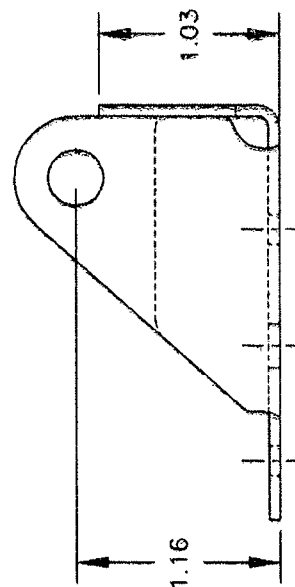
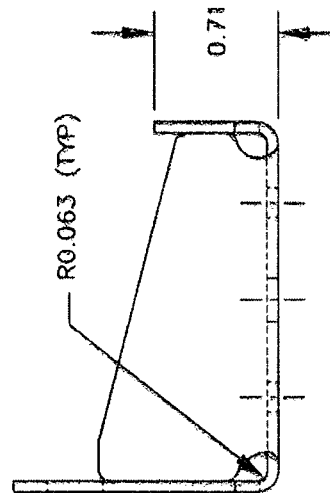
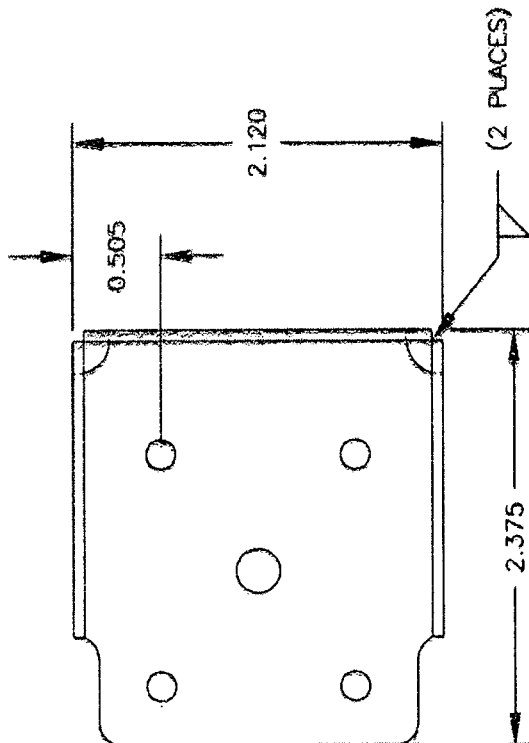


DESIGN BW	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED DIA	APPROVED CA	DRAWING NO. D2144	REV. D SHEET 1 OF 2
DATE 98.10.08		TITLE HINGE BRACKET	SCALE 1:1
A	98.03.17	NEW ISSUE	
C	96.06.05	FLAT PATTERN LAYOUT ADDED	
D	98.10.08	UPDATED DIMS AFTER BEND (TSR A917)	

RELEASED
98.10.15 KE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 35179

PH 10-1-08



FINISH: POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
WELD PER DART QSI 004

W/O:		WORK ORDER CHANGES					
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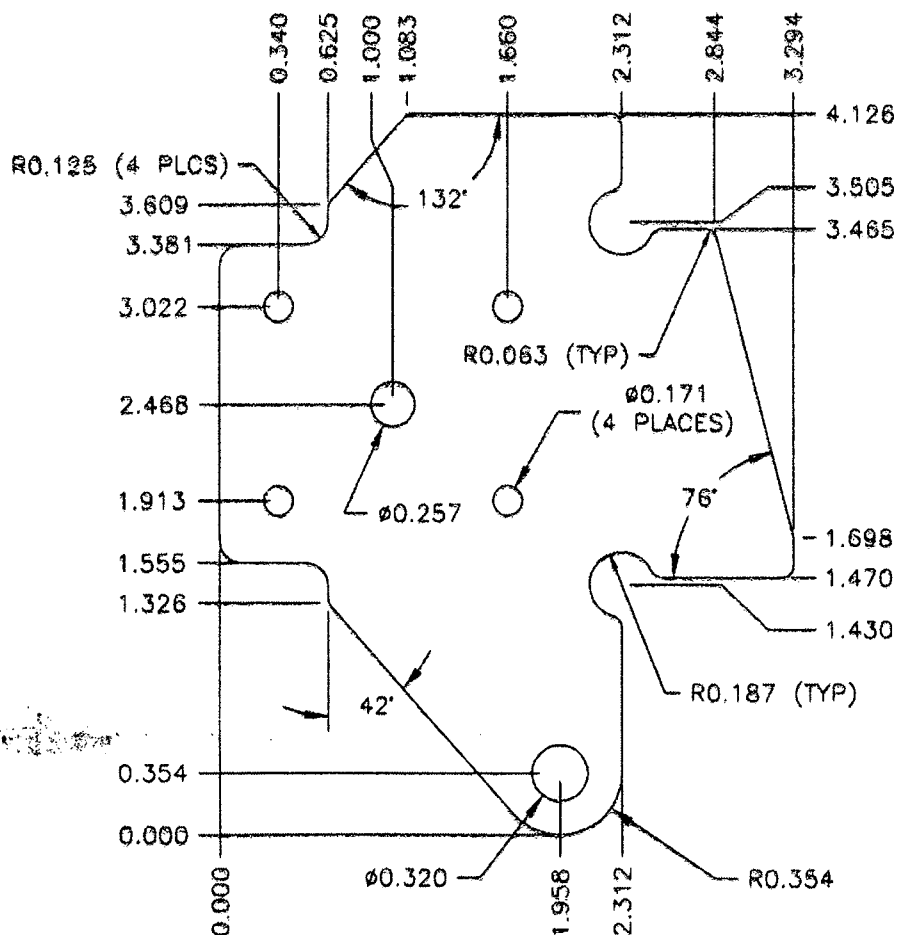
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DESIGN BW	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED MCH	APPROVED QS	DRAWING NO. D2144	REV. D SHEET 2 OF 2
DATE 98.10.08	TITLE HINGE BRACKET		SCALE 1:1

RELEASED
98.10.15



D2144 FLAT PATTERN

MATERIAL: AISI 304/316-2B SS, 0.063 THICK
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

W/O:		WORK ORDER CHANGES					
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